10776

Lark Engineering Company (India) Pvt. Ltd.

I.T.I. Sasoull Road, Yamuna Nagar - 135 001 (Haryana)

Form No.	CNC/QA/FM/02
Rev. No.	01
Rev. Date	31-07-2013

Inprocess Inspection (Pellet Dies)

S.No.	Check Parameter	Specification	Observations	Remarks
1	Work Order No.		16182	30/45
2	Machined By		V.T.I M/c Shop	Dry No = I.E.C.14949
3	Pallet Die No.		15884 (3.0) mm	Rev.00
4	Die Category	Drg. No.	Senior	
5	Out Side Diameter	Drg. No.	510 mm Step OD = 490.9 mm	
6	Inside Diameter	Drg. No.	420.14 mm	Step length = 17.5
7	Width of Pellet Die	Drg. No.	158 mm	
8	Grooves as per Drawing	Drg. No.	12 × 8 × 3 mm / 12 × 8 × 3 mm	
9	Fitting Sizes on CNC Plate	Drg. No.	OK	
10	Drilling Area Surface Smoothness		OK	
11	Tapping Operator		M/c Shop	Tapping No of Holes = 8 Both Side
12	Tapping PCD		454 mm	
13	Tapping Hole Diameter		M20 × Check by M20 Bolt	
14	Tapping On Second Side	Half pitch of 1st side	OK	
15	Tapping Hole Depth		Drill depth = 18.6 mm	Tapping depth = 18.4
16	Perpendicularity of Tapped Hole		yes	
17	Visual Inspection Before Gun Drilling		OK	
	Inspected By (Sign) & Date		Ravi 29/9/25	
1	As per programme no.		—	
2	Gun Drilling Work Completed On		—	
3	Hole Finish In Gun Drilling	Marked	OK	
4	Defective Holes (If Any)		No	

Note : Mark the defective holes/Missed holes with the help of Permanent Marker

Counter = 60°

1	Counter Sinking Depth & Finish	Ok						Row = 24
2	External Relief Dia	3.5 mm	outside (2-2)		Inner			
3	External Relief Depth		18 mm		15 mm			
4	Inspection Done Before Hardening By (Name)		Ravi					
5	Material Sent For Hardening By (Name)		Lark Furnace					
6	Material Sent For Hardening On Date			29	9	25		
	Inspected By (Sign) & Date		Ravi 29/9/25					

Sato 29/9/25.

Reviewed by (Engineer-CNC)

Manager-QA